

Date: Wednesday, 2/20/2008 4:21:26 PM
 User: Kim Johnston

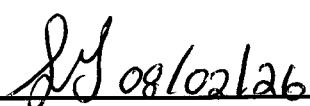
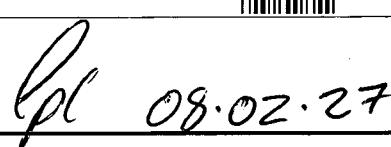
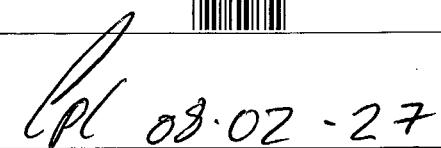
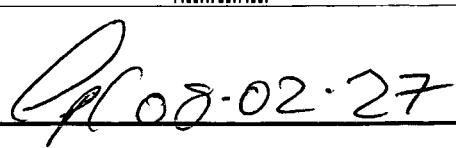
Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	LOW PROFILE BASKET LID ASS'Y		
Job Number	37528			Part Number	D3713042		
Estimate Number	13153			Drawing Number	D3713 U/R		
P.O. Number	:			Project Number	N/A		
This Issue	2/20/2008	S.O. No.	:	Drawing Revision	U/R		
Prsht Rev.	NC			Material	:		
First Issue	11	Type	LARGE FAB ASSY	Due Date	3/10/2008		
Previous Run	37527			Qty:	1	Um:	Each
Written By	<u> </u>						
Checked & Approved By	<u> </u>						
Comment	Est Rev:A new issue 08-01-30 DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
		
Comment: Qty.: 32.5731 f(s)/Unit Total : 32.5731 f(s) 304 SQ Tube.75x.75x.065W 1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing. QTY PART NUMBER BATCH 2 D3714-1 <u>M107038</u> 2 D3715-1 <u>M107038</u> 10 D3716-1 <u>M107038</u> 4 D3732-1 <u>M107038</u> <u>F</u> <u>2222</u> <u>2222</u>		
		
2.0	D23271	Spacer Bushing
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Spacer Bushing <u>batch 336920</u>		
		
3.0	D2581	Mounting Bracket
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Mounting Bracket <u>batch B36591</u>		
		
4.0	D37491	HINGE HALF
		
Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) HINGE HALF <u>batch P37202</u>		
		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:21:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 37528

Part Number: D3713042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0

D2329

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label Plate

batch 335686

PL 08-02-27

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- drill holes in both D3715-1 as per dwg D3715

PL 08/02/26

2- deburr

PL 08/02/26

3- assemble as per dwg D3713 and weld as per QSI004

PL 08-02-27

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 17.8500 sf(s)/Unit Total : 17.8500 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty Part Number

Description

Batch

17sq.ft M304EX0.75-16F

Expanded Metal

M106884

PL 08-02-27

10.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh as per dwg D3743

PL 08-02-27

2- weld mesh as per dwg D3713

PL 08-03-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:21:26 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 37528

Part Number: D3713042

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC5

INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

ASS 08.03.10/508/08/10

Comment: INSPECT WORK TO CURRENT STEP

12.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-07 ①

13.0 POWDER COATING

POWDER COATING



M/00700

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FD 08/03/11 ①

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PK 08-03-11

15.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



M 106894

①

Comment: Wing Walk as per Dwg D3713 and QSI 005 4.4

BP 08-03-11

16.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08-03-12

17.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 08-03-12

①

18.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2008/3/13

①

POSITIVE RECALL

EFFECTIVE 08/03/11 AUTH 4

RELEASED _____ DATE _____

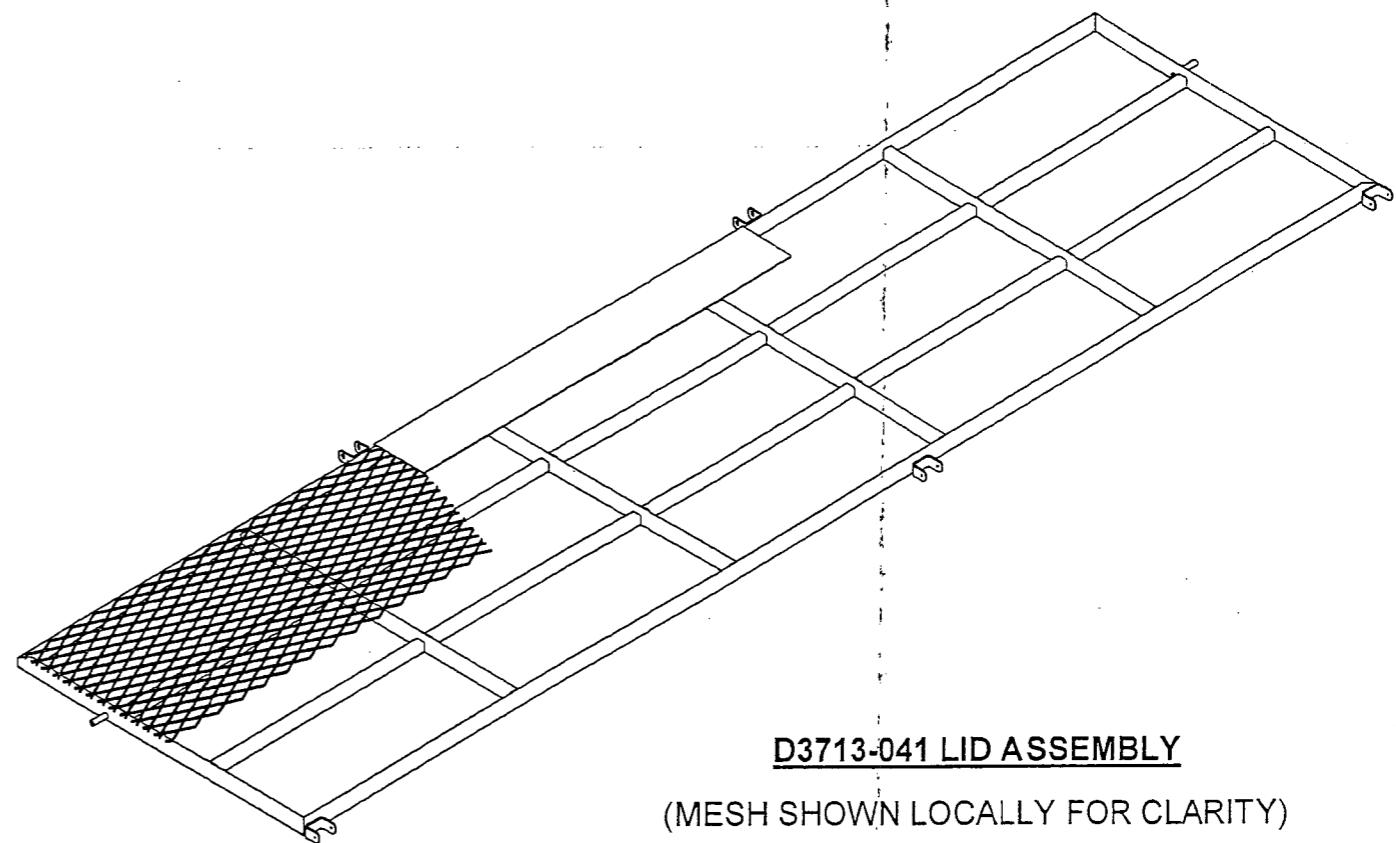
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY.	PART NUMBER	DESCRIPTION
X	D3713-041	LID ASSY LOW PROFILE BASKET
2	D2327-1	SPACER
1	D2329	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3714-1	RIB
2	D3715-1	RIB
10	D3716-1	RIB
4	D3732-1	RIB
1	D3743-1	MESH
3	D3749-1	HINGE HALF



D3713-041 LID ASSEMBLY

(MESH SHOWN LOCALLY FOR CLARITY)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37528

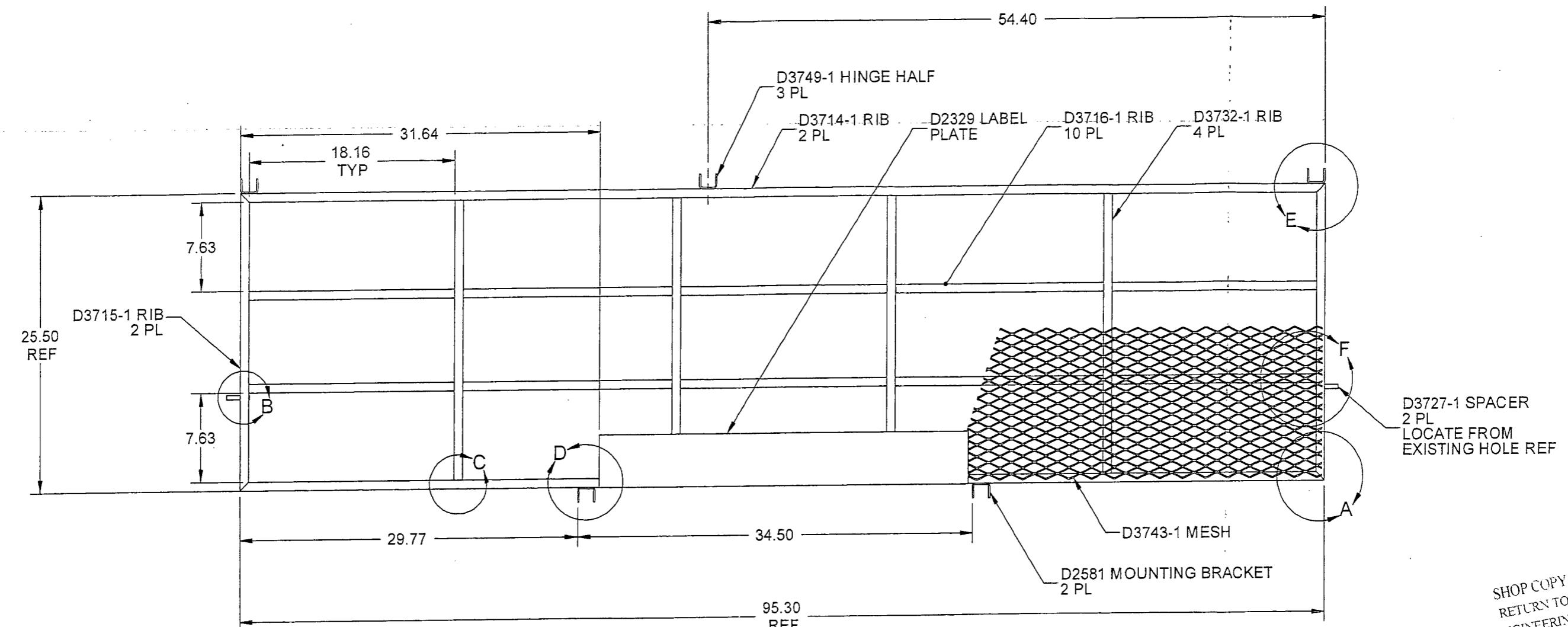
PRELIMINARY ISSUE

LE 08.02.15

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 36 lbs APPROX.
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3713	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LID ASSEMBLY	NTS
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D3713-041 LID ASSEMBLY

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CHECKED	<i>CE</i>	DRAWING NO.	REV. A
MFG. APPR.		D3713	SHEET 2 OF 3
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